

Work Order ID 66611 -1

SPLIT!



Page 1

Item ID: D3315-5

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 2/22/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: mk

Date: 11-02-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

FB11-2-22

⑥

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FB11-2-22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

mk 11/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66611

Tuesday, February 22, 2011 3:12:04 PM

Page 2

Item ID: D3315-5

Accept

Revision ID:

Item Name: Wearplate

Start Date: 2/22/2011 Start Qty: 5.00

Required Date: 2/25/2011 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1- Form using DT8751 Die as per Dwg D3315 Rev: B
2- Form using DT8179 Die as per Dwg D3315 Rev: B

0.00

0.00

140



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

150



Large Fab

Large Fab

Large Fab

Memo

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: B
Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod 116678

0.00

0.00



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

(1)

(H)
-5

11.02.23 1

W/O:		WORK ORDER CHANGES					
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Work Order ID 66611

Tuesday, February 22, 2011 3:12:04 PM



Page 3

Item ID: D3315-5

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/22/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/11/02/23

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/11/02/23



180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45

300°

12:15

1 BR 11-2-23.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 66611

Tuesday, February 22, 2011 3:12:04 PM



Page 4

Item ID: D3315-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/22/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 6 11/02/23

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3315-5, B/N: BXXXXX
For Product Eligibility see PDA04-17
and Stock
Location: _____

11/02/23

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/23

MF 11-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 3:12:01 PM

Page 1

Work Order ID: 66611

Parent Item: D3315-5

Parent Item Name: Wearplate



Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 05.05.12 ☐ New issue ☐ KJ/JLM
 IPP Rev:B As per Rev B 06-03-24 JLM
 IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

93.1250

1.8345

9.655263

12

1811-2-22



1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT

81

116791

81

MAT19

12.125

111410

12.125

111410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	06611
Description: Wearplate		Part Number:	D3315-5
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	x		M+ape	
30.215	+/-0.010	30.215	x			
24.215	+/-0.010	24.215	x			
21.611	+/-0.010	21.611	x			
17.965	+/-0.010	17.965	x			
16.026	+/-0.010	16.026	x			
14.735	+/-0.010	14.735	x			
12.815	+/-0.010	12.815	x			
6.465	+/-0.010	6.465	x			
5.464	+/-0.010	5.471	x			
4.527	+/-0.010	4.528	x			
3.550	+/-0.010	3.557	x			
5.214	+/-0.010	5.209	x			
Ø0.300	+0.006/-0.001	0.304	x		✓	
Ø0.266 x 0.575	+/-0.010	0.267 x 0.577	x		✓	
Ø0.266 x 0.450	+/-0.010	0.268 x 0.451	x		✓	

Measured by: <u>IB</u>	Audited by: <u>mf</u>	Prototype Approval:	N/A
Date: <u>11-2-22</u>	Date: <u>11/02/23</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	<u>DD</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

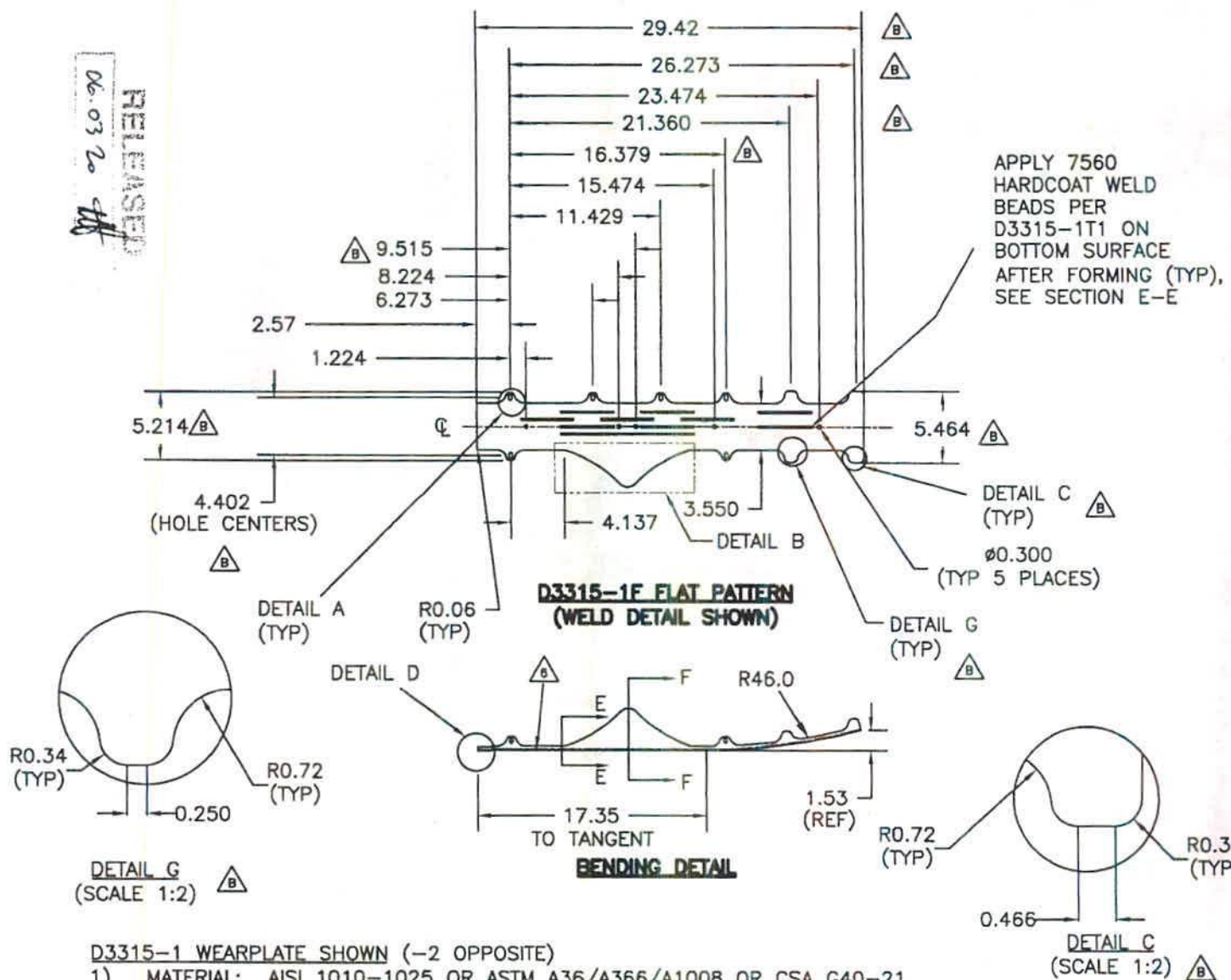
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GH</i>	APPROVED <i>GH</i>	DRAWING NO.	REV. B
DATE 06.01.31		D3315	SHEET 1 OF 4
		TITLE	SCALE
		WEARPLATE	1:1
A	04.09.10	NEW ISSUE	
B	06.01.31	UPDATE DIMENSIONS	



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

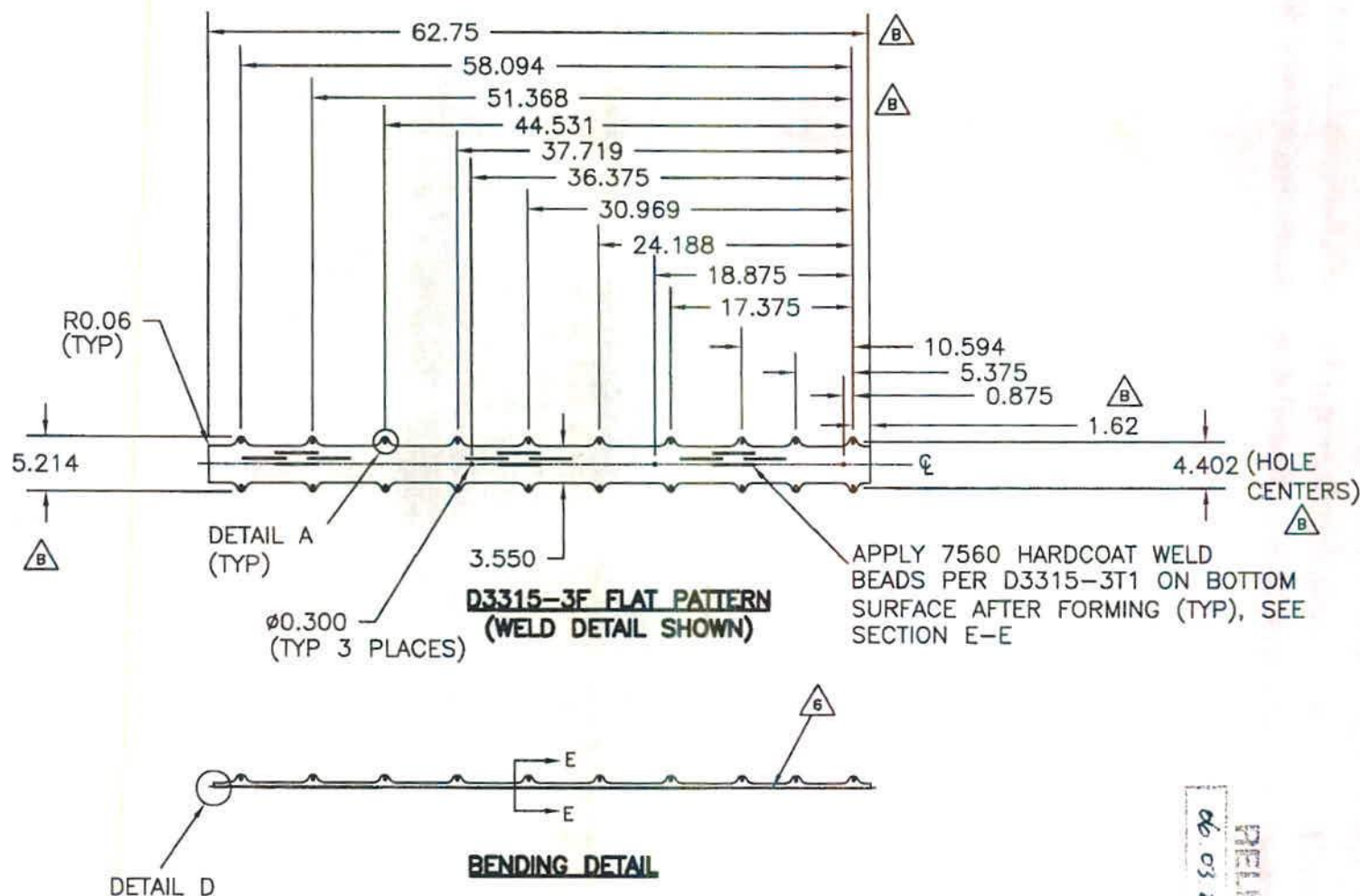
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

06 03 20 JH

DESIGN	84	UNKNOWN BY	84	DARI AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>CH</i>	APPROVED	<i>CH</i>	DRAWING NO.	REV. B
				D3315	SHEET 2 OF 4
DATE				TITLE	SCALE
06.01.31				WEARPLATE	1:16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

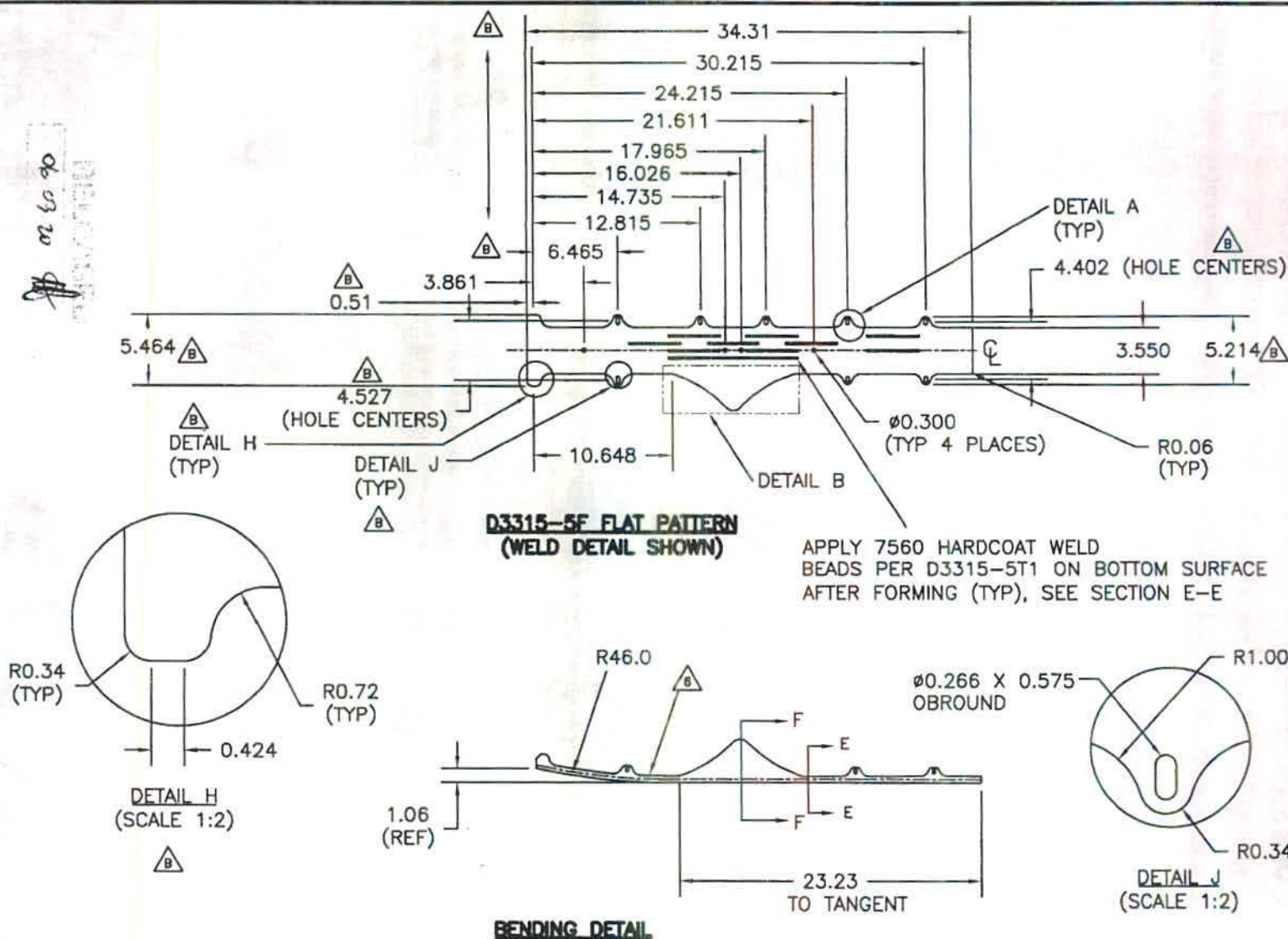
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
814	814	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 3 OF 4
		SCALE 1:12



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

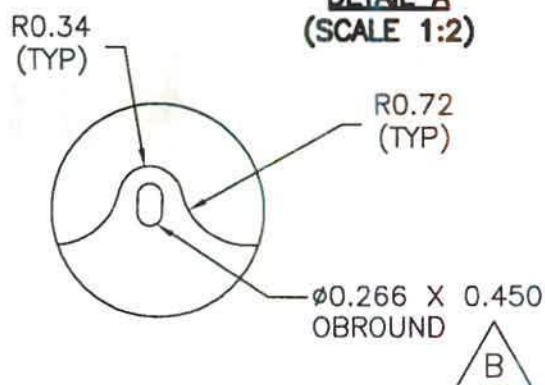
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. B
DATE	06.01.31	TITLE	D3315	SHEET 4 OF 4
		WEARPLATE		SCALE NTS

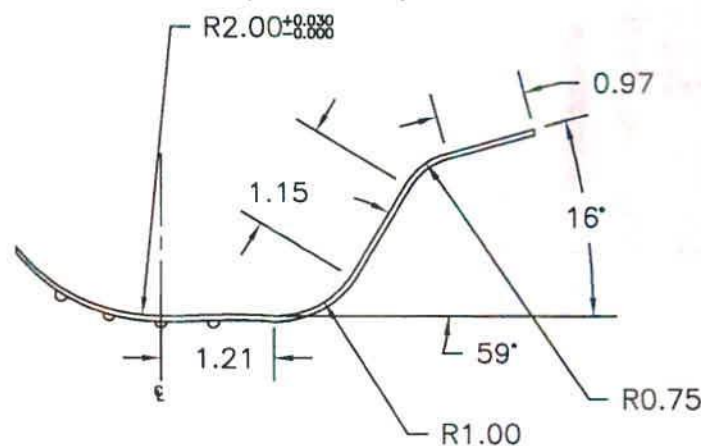
DETAIL A
(SCALE 1:2)



0.063
JOGGLE

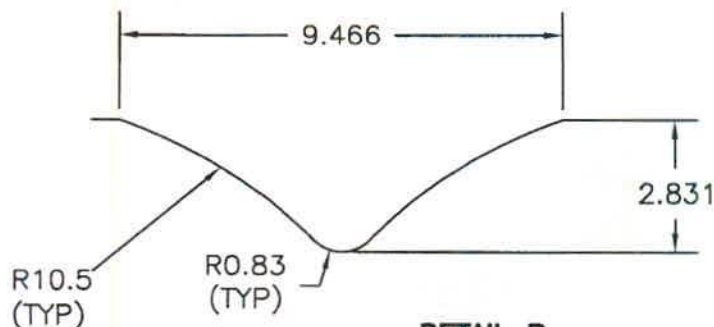
1.000
JOGGLE

DETAIL D
(SCALE 1:2)

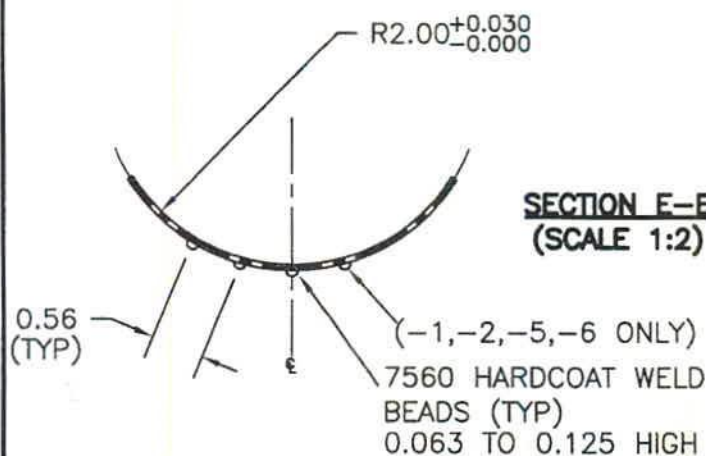


SECTION F-F
(SCALE 1:2)

DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)



(-1,-2,-5,-6 ONLY)
7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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